

# Work Order ID 52346

Tuesday, September 22, 2009 2:32:23 PM



Page 1

Item ID: D2600-3-BENT

Accept



Setup Start



Revision ID: D1/F

Stop



Item Name: Extrusion Bent

Start Date: 9/23/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: *BP*

Date: *09-22*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2600

Rev D1

100

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Pick qty 1 D2600-3-120 extrusion

1-Deburr one end of extrusion

*BE 09/10/14*

2-Drill #30 pilot holes using DT8689

*BE 09/10/14*

3-Open holes to 5/16" and deburr

*BE 09/10/14*

4-Bend using CNC bending machine as per program 2750.C and Folio FT003.

5-Use 5/16 locator pin on buggy "A".

6-Check fit to Jig DT8150

*DD 09-10-14*

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Inspect work to Step 6 Ensure fit to Jig DT8150

*27 S 09/10/14*

*(Signature)*

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

Identify as per dwg & Stock Location: 46

0.00



Packaging

Memo

0.00

Packaging

*DP* 9-10-14 (20)

130

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/15 *[Signature]*  
09-10-15

# Picklist Print

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Tuesday, September 22, 2009 2:32:23 PM

Work Order ID: 52346



Parent Item: D2600-3-BENTRevD1/F



Parent Item Name: Extrusion Bent

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2600-3-120RevD1		Manufactured	No			100	Each	95.0000	20.0000			

Extrusion Round 3" 350

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

95

43960

42

46063

53

15 20 86 09/10/14

SHOP COPY  
RETURN TO  
ENGINEERING



WITHOUT NOTICE  
WORK ORDER  
NO. 52346



DESIGN <i>DM</i>	DRAWN BY <i>DM</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>AS</i>	DRAWING NO. D2600	REV. 0 SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
DI	01.04.17	ADD PART NUMBERS & DIE NUMBERS <i>4-CP</i>	

RELEASED  
98.08.25 DS

#### GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi  
MINIMUM ELONGATION = 8 %

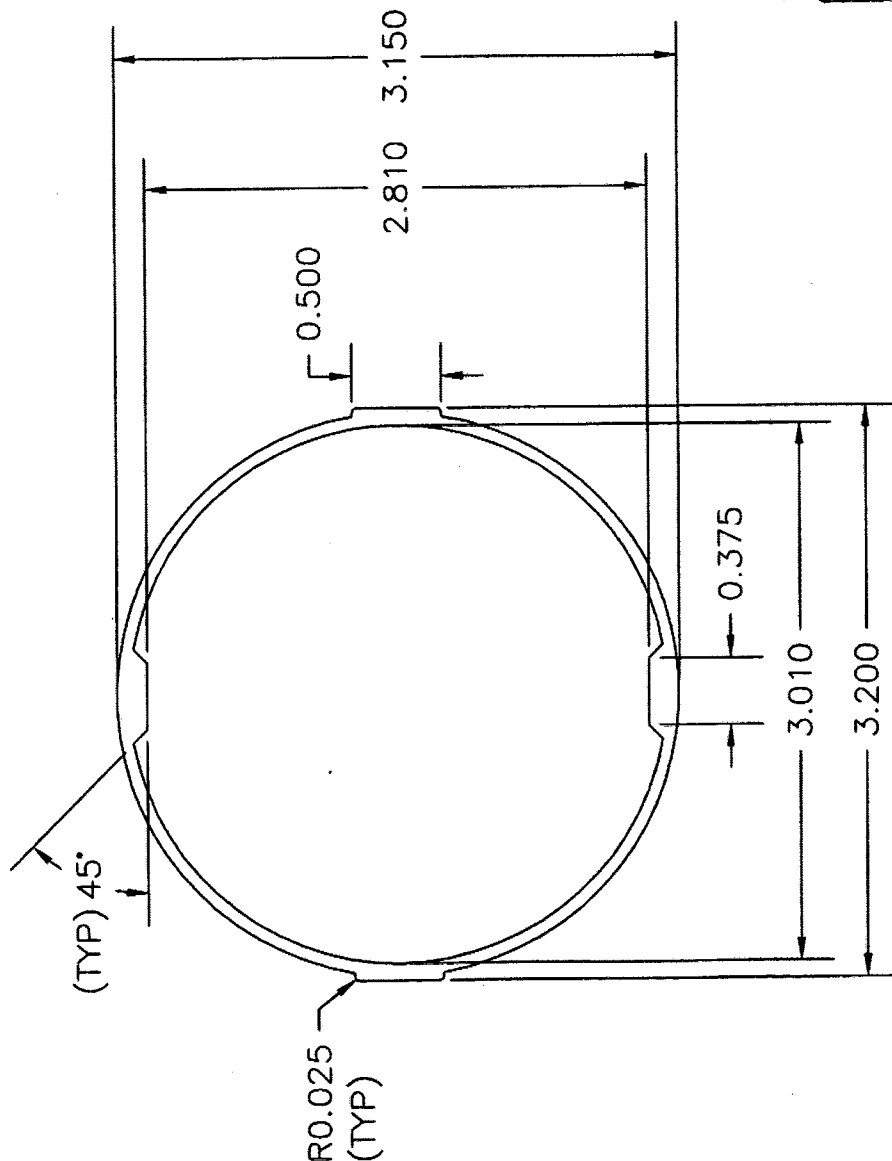
A SAMPLE FROM EACH BATCH WILL BE PULL TESTED  
TO ASTM STANDARD B221 BY AN APPROVED TESTING  
FACILITY TO ENSURE THAT THE BATCH MEETS THE  
ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5. ALL DIMENSIONS ARE IN INCHES.



DESIGN <i>DD</i>	DRAWN BY <i>DD</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2600	REV. D SHEET 2 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED  
98.8.25 DS



D2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870  
OR BON L DIE # 897121 (PREFERRED CHOICE)

PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)



52346



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
KE	[Signature]	D2600	SHEET 3 OF 5
DATE	TITLE	SCALE	
98.08.20	EXTRUSION	1:1	

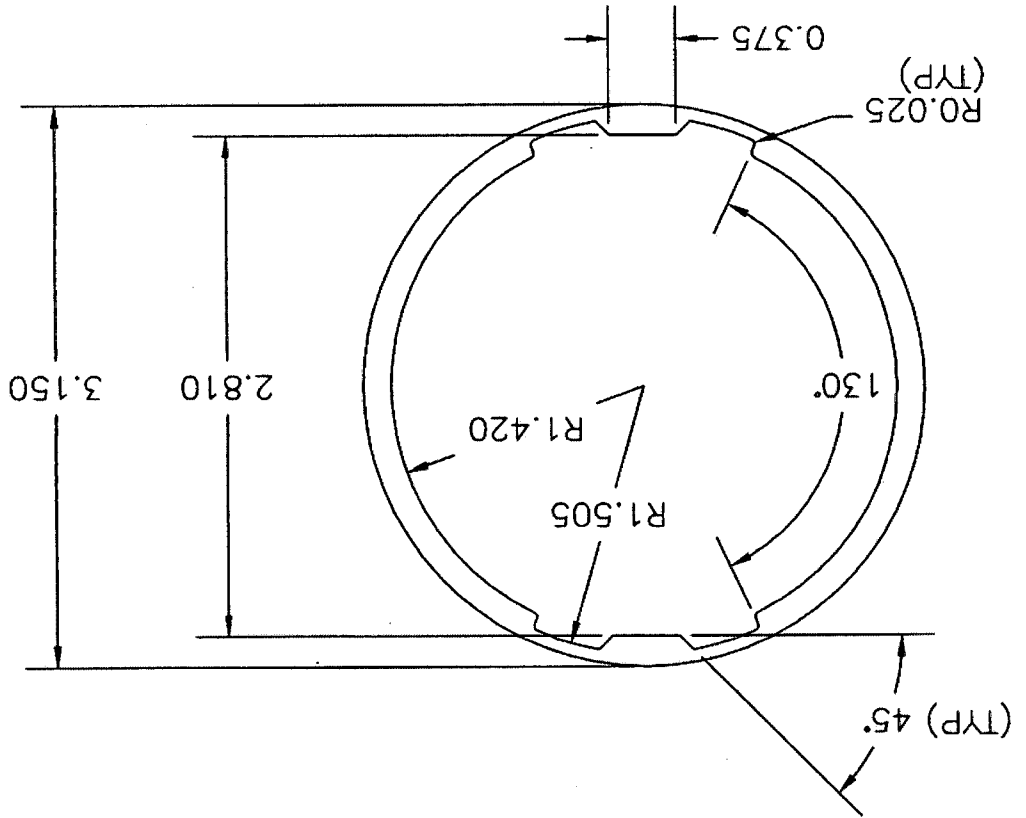
**RELEASED**  
98.8.15 DS

**D2600-3**

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859

OR BON L DIE # 897122 (PREFERRED CHOICE)

PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-3-120 IS 120" LONG)

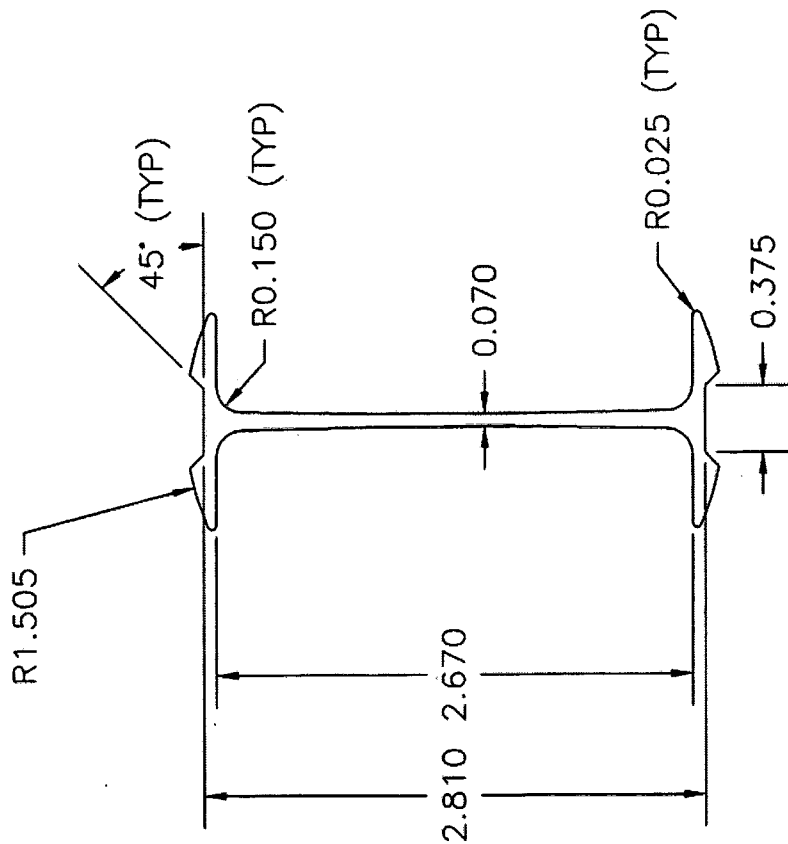


52346



DESIGN <i>MB</i>	DRAWN BY <i>MB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2600	REV. D SHEET 4 OF 5
DATE 98.08.20	TITLE EXTRUSION		SCALE 1:1

RELEASED  
98.8.25. DS



D2600-5

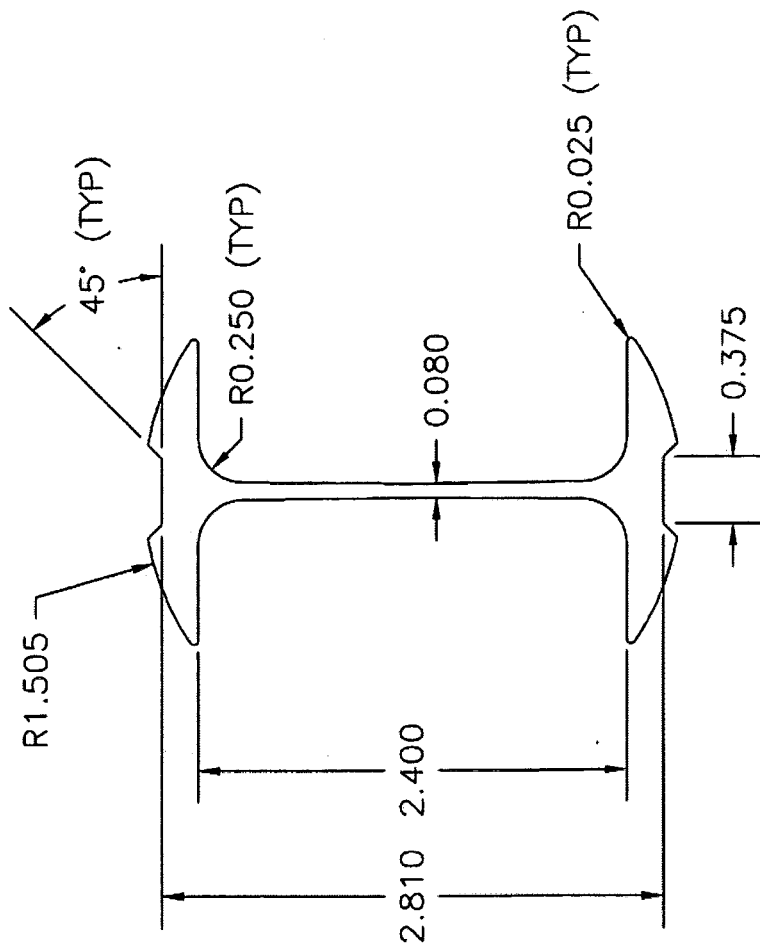
MANUFACTURED WITH CARADON INDALEX DIE # MS-18871  
PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES  
(EG. D2600-5-108 IS 108" LONG)



52346

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. 0 SHEET 5 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

**RELEASED**  
98.8.25 DSD2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872  
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES  
(EG. D2600-7-125 IS 125" LONG)

